

Date: Tuesday, 9/4/2007 11:29:27 AM  
User: Kim Johnston

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : INLET VALVE SHAFT
Job Number : 34392	
Estimate Number : 12252	
P.O. Number : <i>N/A</i>	Part Number : D34747
This Issue : 9/4/2007 S.O. No. : <i>N/A</i>	Drawing Number : D3474 REV.A
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : 26993	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 10/4/2007 Qty: 6 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : est rev. A 06.04.20 New issue EC	

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 SILF36X36X116 Gasket



*M51605125*



Comment: Qty.: 0.0540 sf(s)/Unit Total : 0.3240 sf(s)  
high temp. silicone sheet .125 batch: *M160165 HB 07-09-06*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

Cut as per Dwg D

Dwg Rev: *A*

Prog Rev: *A*

*HB 07-09-07*

*(12)*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



*HB 07-09-07*



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*EO 01/01/10 (12)*

*counter*

5.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *3F 100*

*7/8/10*

*SD*

*(12x)*

6.0 QC21 FINAL INSPECTION/W/O RELEASE



*(12)*

Comment: FINAL INSPECTION/W/O RELEASE

*07/09/11*

Job Completion



*u 07/09/11*

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes ☒ No ☐ DQA: ☒ Date: 01/09/11

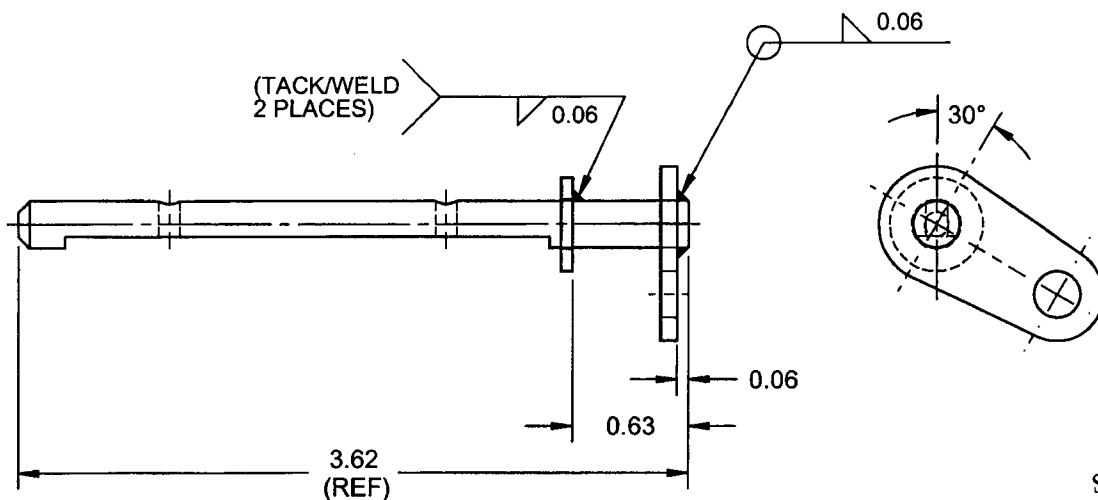
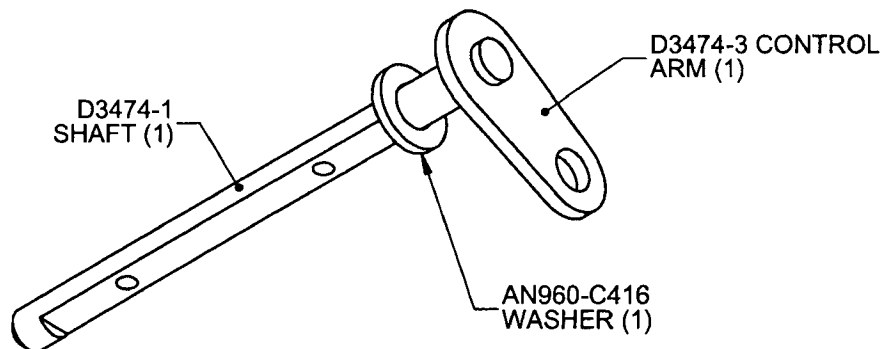
QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**DART**

DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3474</b>	REV. A SHEET 1 OF 4
DATE <b>06.01.23</b>		TITLE <b>INLET VALVE SHAFT</b>	SCALE 1:1
A	06.01.23	NEW ISSUE	

*[Signature]* 06.04.03**D3474-041 INLET VALVE SHAFT**

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SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. *34392*

**NOTES:**

- 1) SPOT WELD PER DART QSI 004
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

QTY -041	P/N	DESCRIPTION
X	D3474-041	INLET VALVE SHAFT
1	D3474-1	SHAFT
1	D3474-3	CONTROL ARM
1	AN960-C416	WASHER

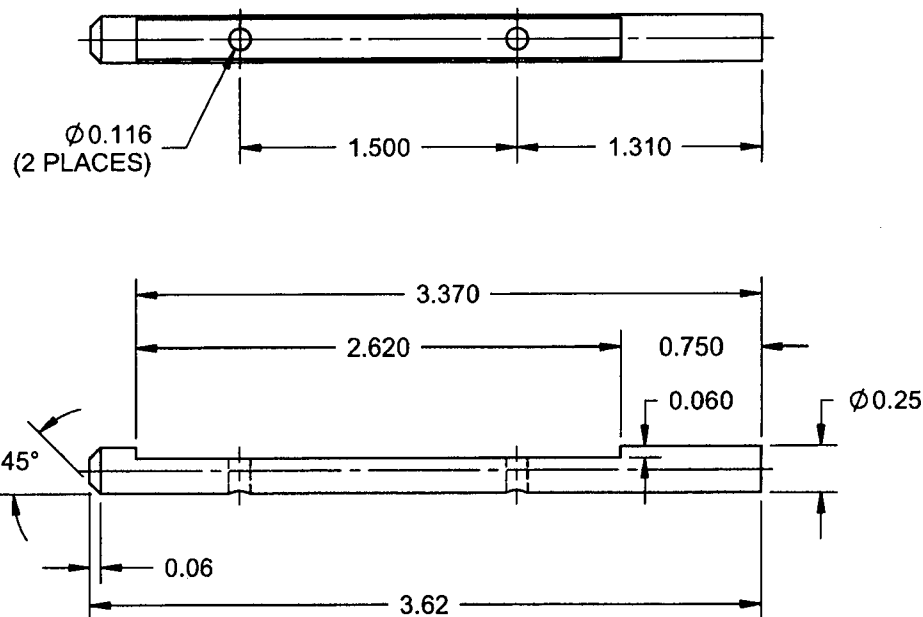
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DATE <b>06.01.23</b>		TITLE <b>INLET VALVE SHAFT</b>	SCALE 1:1

*[Signature]* 06.04.03**D3474-1 SHAFT****NOTES:**

- 1) MATERIAL: AISI 303 STAINLESS STEEL 0.25 ROUND BAR  
(REF. DART SPEC. M303R0.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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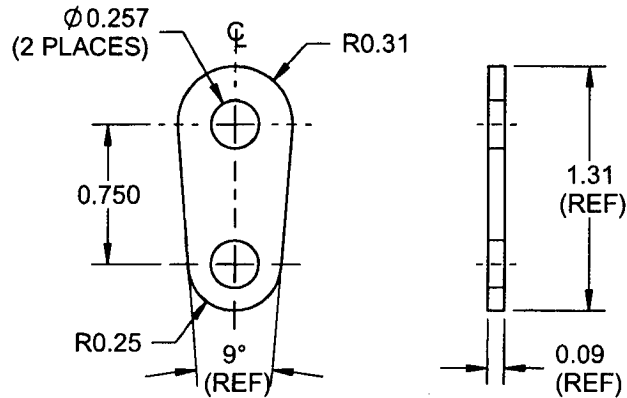
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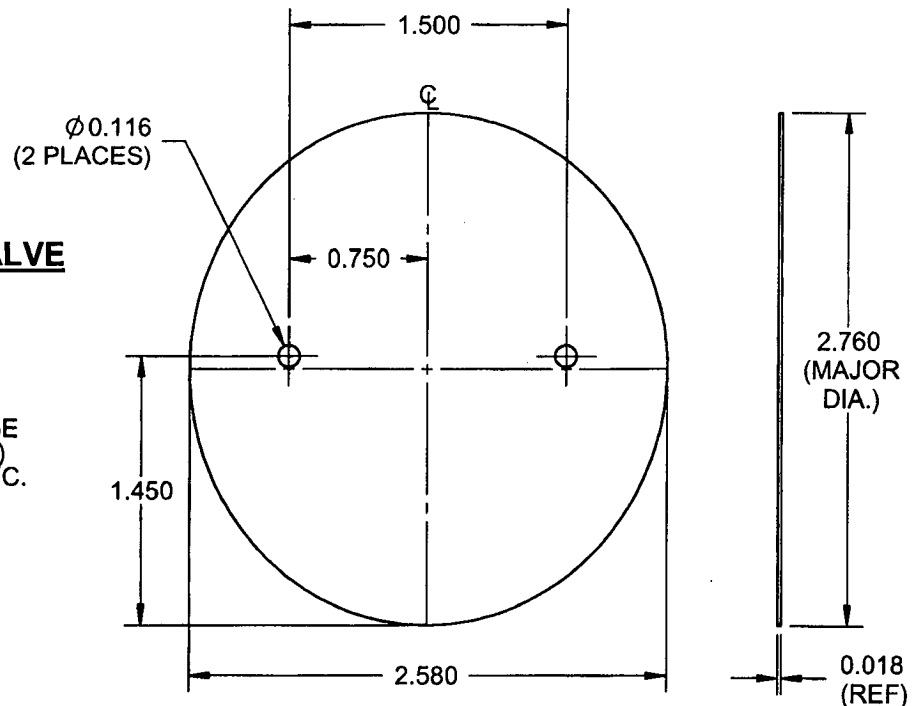
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3474</b>	REV. A SHEET 3 OF 4
DATE <b>06.01.23</b>		TITLE <b>INLET VALVE SHAFT</b>	SCALE 1:1

*# 06.04.03***D3474-3 CONTROL ARM  
FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 SS SHEET PER  
MIL-S-5019 (ANNEALED) 2B  
FINISH 13 GAUGE SS  
(0.090 THICK)  
(REF. DART SPEC. M304S13GA)

**D3474-5 BUTTERFLY VALVE  
FLAT PATTERN**

- 1) MATERIAL: AISI 304/316 SS  
SHEET PER  
MIL-S-5019  
(ANNEALED) 2B  
FINISH 26 GAUGE  
SS (0.018 THICK)  
(REF. DART SPEC.  
M304S26GA)

**NOTES:**

- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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WORK ORDER  
*34392*

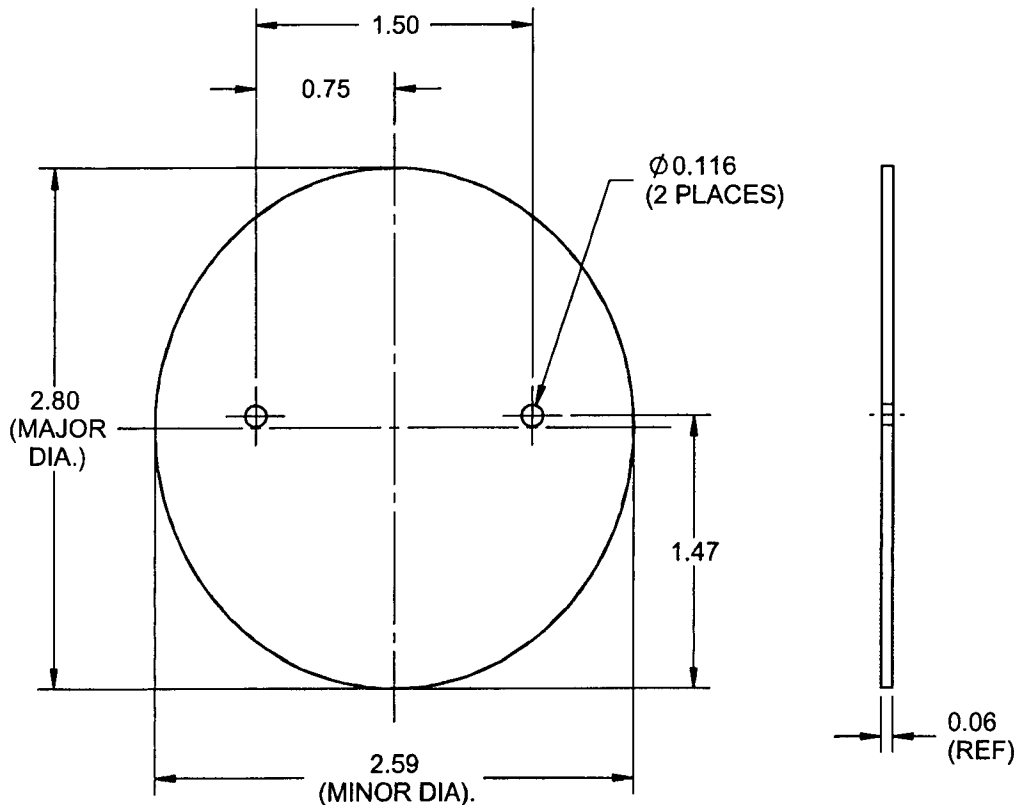
NO. *34392*

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DATE <b>06.01.23</b>		TITLE <b>INLET VALVE SHAFT</b>	SCALE 1:1

*[Signature]* 06.04.03**D3474-7 BUTTERFLY VALVE SEAL****NOTES:**

- 1) MATERIAL: RED (OR GRAY) 60 DUROMETER HI-TEMPERATURE SILICONE SHEET, 0.063 THICK (REF. DART SPEC. M-SIL60-S.063)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DART AEROSPACE LTD		Work Order:	34392
Description: INLET VALVE GASKET		Part Number:	D3474-7
Inspection Dwg:	Rev: A	Page 1 of 1	

# FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article      ☐ Prototype

[illegible]

Measured by: <b>HB</b>	Audited by: <b>ER</b>	Prototype Approval: <b>n/a</b>
Date: <b>07-09-07</b>	Date: <b>07/09/10</b>	Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	



